

## **ALLROUNDER 470 E**

### **GOLDEN ELECTRIC**

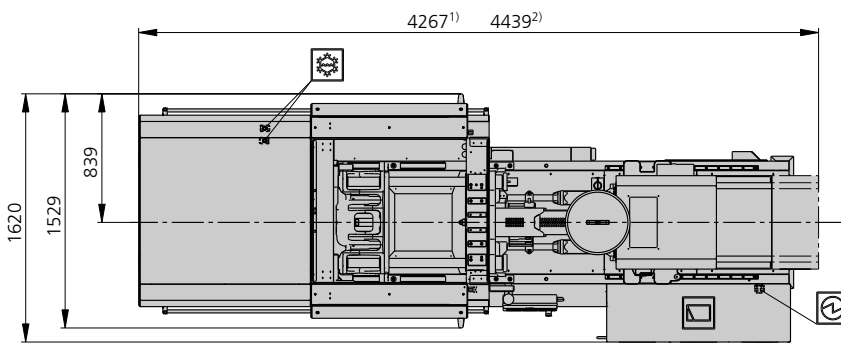
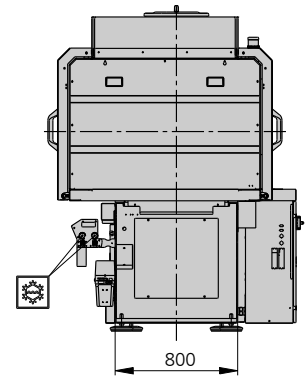
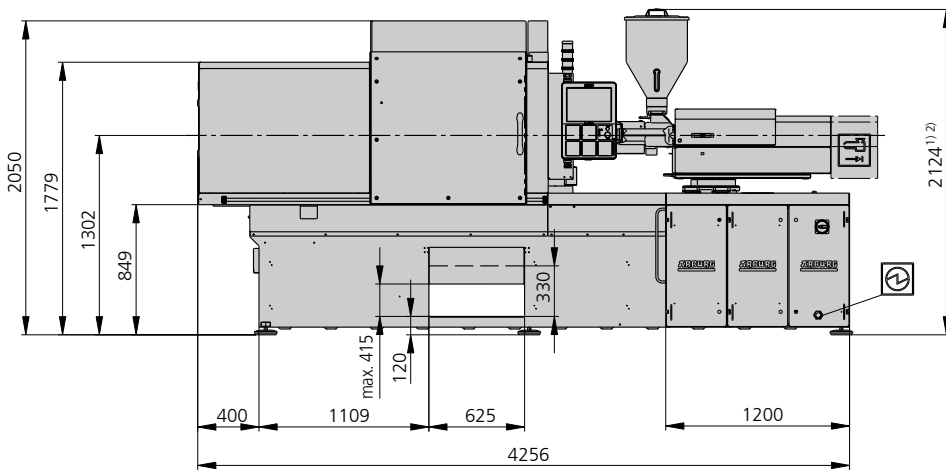
Distance between tie bars: 470 x 470 mm

Clamping force: 1000 kN

Injection unit (acc. to EUROMAP): 170, 290

**ARBURG**

# MACHINE DIMENSIONS | 470 E GOLDEN ELECTRIC



Electrical connection



Cooling water connection

1) Injection unit 170  
2) Injection unit 290

# TECHNICAL DATA | 470 E GOLDEN ELECTRIC

Clamping unit		470 E GOLDEN ELECTRIC	
with clamping force	max. kN	1000	
Opening force   stroke	max. kN   mm	---   350	
Mould height, fixed   variable	min.-max. mm	---   250-500	
Platen daylight fixed   variable	max. mm	---   600-850	
Distance between tie bars (w x h)	mm	470 x 470	
Mould mounting platens (w x h)	max. mm	637 x 637	
Weight of movable mould half	max. kg	760	
Ejector force   stroke	max. kN   mm	40   175	
Dry cycle time EUROMAP <sup>2</sup>	min. s - mm	1,4 - 329	

Injection unit		170			290		
with screw diameter	mm	25	30	35	30	35	40
Effective screw length	L/D	24	20	17	23,3	20	17,5
Screw stroke	max. mm	120			150		
Calculated stroke volume	max. cm <sup>3</sup>	59	85	115	106	144	188
Shot weight	max. g PS	54	77	105	97	132	172
Material throughput	max. kg/h PS	10	13,5	16	17	20,5	24,5
	max. kg/h PA6.6	5	7	8	8,5	10,5	12,5
Injection pressure	max. bar	2500	2000	1470	2500	2000	1530
Holding pressure time	max. s - bar	300-2300	300-1600	300-1170	300-2180	300-1600	300-1220
Injection flow <sup>2</sup>	max. cm <sup>3</sup> /s	78	114	154	98	134	176
		[102]	[148]	[202]	[128]	[176]	[230]
Injection speed <sup>5</sup>	max. mm/s	160			140		
	max. mm/s	[210]			[180]		
Screw circumferential speed	max. m/min	31	37	44	28	33	37
Screw torque	max. Nm	210	250	290	320	380	430
Nozzle contact force   retraction stroke	max. kN   mm	50   300			50   300		
Heating capacity   zones	kW	9,4   5			6,4   5		
Feed hopper	l	50			50		

Drive and connection		170		290	
with injection unit		170		290	
Net weight of machine	kg	4900		5000	
Sound press. level   Insecurity <sup>4</sup>	dB(A)	55   3		55   3	
Electrical connection <sup>3</sup>	kW	21		21	
	Total	A		63	
	Machine	A		---	
	Heating	A		---	
Cooling water connection	max. °C	35		35	
	min. Δp bar	1,5   DN 25		1,5   DN 25	

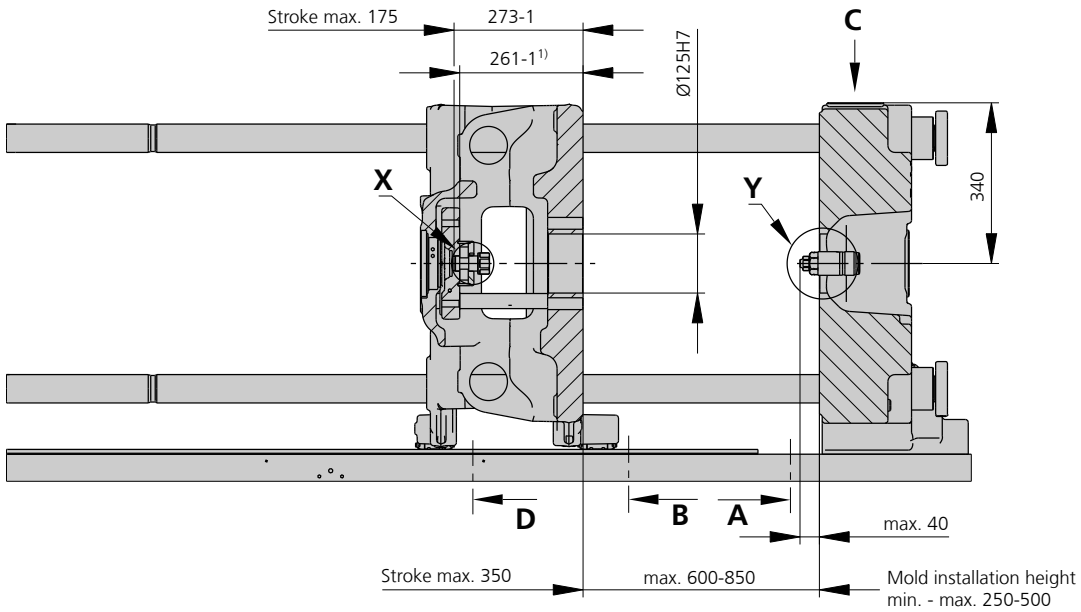
**Machine type**  
with EUROMAP size designation <sup>1</sup>  
470 E GOLDEN ELECTRIC 1000-170 | 290

**Upon request: other machine types and mould installation heights, screws, drive powers etc.**

All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection pressure and max. injection flow may be mutually exclusive.

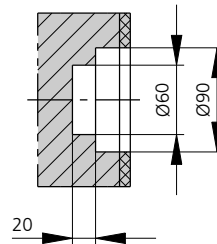
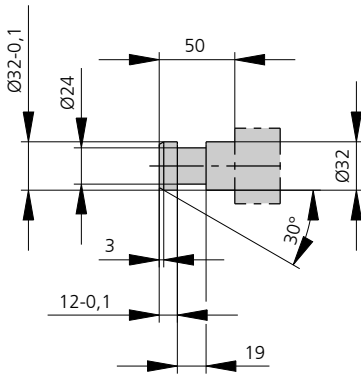
- 1) Clamping force (kN) - size of injection unit = max. stroke volume (cm<sup>3</sup>) x max. injection pressure (kbar)
  - 2) Specification of maximum injection flow at maximum injection pressure.
  - 3) Specifications relate to 400 V/50 Hz.
  - 4) Detailed info in the operating instr.
  - 5) Forward speed of plasticising screw at 1000 bar injection pressure.
- [ ] Specifications apply to alternative equipment.

# MOULD INSTALLATION DIMENSIONS | 470 E GOLDEN ELECTRIC



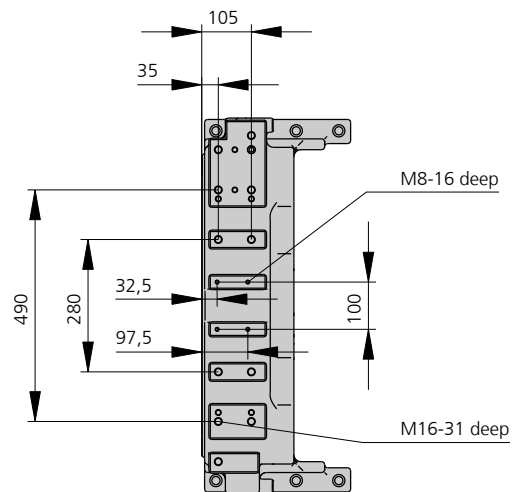
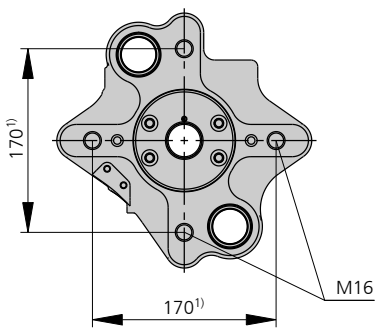
**Ejector bolt | X**

**Bore in mould (if required) | Y**



**Ejector plate | D**

**Robotic system mounting | C**



1) Position of ejector plate



# SHOT WEIGHTS | 470 E GOLDEN ELECTRIC

## Theoretical shot weights for the most important injection moulding materials

Injection units according to EUROMAP		170			290		
Screw diameter	mm	25	30	35	30	35	40
Polystyrene	max. g PS	54	77	105	97	132	172
Styrene heteropolymerizates	max. g SB	53	76	103	95	129	168
	max. g SAN, ABS <sup>1)</sup>	52	74	101	93	126	165
Cellulose acetate	max. g CA <sup>1)</sup>	61	87	119	109	148	194
Celluloseacetobutyrate	max. g CAB <sup>1)</sup>	56	81	110	101	138	180
Polymethyl methacrylate	max. g PMMA	56	80	109	100	136	178
Polyphenylene ether, mod.	max. g PPE	50	72	98	90	122	160
Polycarbonate	max. g PC	57	81	111	102	139	181
Polysulphone	max. g PSU	58	84	115	105	143	187
Polyamides	max. g PA 6.6   PA 6 <sup>1)</sup>	53	77	104	96	131	171
	max. g PA 6.10   PA 11 <sup>1)</sup>	50	72	98	90	122	160
Polyoximethylene (Polyacetal)	max. g POM	66	96	130	120	163	213
Polyethylene terephthalate	max. g PET	64	92	126	115	157	205
Polyethylene	max. g PE-LD	41	59	80	73	100	130
	max. g PE-HD	42	60	82	76	103	134
Polypropylene	max. g PP	43	62	84	77	105	137
Fluoropolymerides	max. g FEP, PFA, PCTFE <sup>1)</sup>	86	124	169	155	211	276
	max. g ETFE	76	109	148	136	185	242
Polyvinyl chloride	max. g PVC-U	65	94	127	117	159	208
	max. g PVC-P <sup>1)</sup>	60	87	118	108	147	192

1) average value

**ARBURG GmbH + Co KG**  
 Arthur-Hehl-Strasse  
 72290 Lossburg  
 Tel.: +49 7446 33-0  
 www.arburg.com  
 contact@arburg.com